

**Work Order ID 71717**

Page 1

Thursday, July 07, 2011 1:00:46 PM

Item ID: D3296-3

Accept



Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: CLDate: 11/07/07

Tooling:

Date:

Run Start



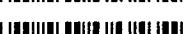
QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3296

Rev A

100



FLOW WATER JET

0.00

ST 11/08/11

B11-8-12

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3296  Dwg Rev: A  Prog Rev: A  2-  
Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

B11-8-12

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

8/10/12



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 71717**

Thursday, July 07, 2011 1:00:46 PM



Page 2

Item ID: D3296-3

Accept



Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:	Stop	



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
	Memo								
	Deburr								
		148							
140	Chemical Conversion Coat per QSI005 4.1	0.00							
	Memo								
	Hand Finish								
	Hand Finishing								
150	QC3- Inspect Part Finish	0.00							
	Memo								
	QC								
	Quality Control								

12 of 1108/15

12x8 m/s works

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 71717**

Thursday, July 07, 2011 1:00:46 PM



Page 3

Item ID: D3296-3

Accept



Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
Description

160

Identify as per dwg & Stock Location: 196

Packaging

Packaging

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

11/18/15 12

Memo

0.00

QC21- Final Inspection - Work Order Release

0.00

0.00

QC21- Final Inspection - Work Order Release

0.00

11/18/1511-08-1412

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Thursday, July 07, 2011 1:00:44 PM

Page 1

Work Order ID: 71717



Parent Item: D3296-3



Parent Item Name: Door Panel

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C05.10.14 Added step 14 KJ/EC  
IPP Rev:E Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			110	sf	250.3800	0.6532	4.125474	8	1311-8-12	

2024-T3 .063 sheet

Location	Loc Qty	Loc Code
MAT022	250.38	
117018	25.88	
117392	224.5	

117392

12

4.5 90 11/08/11  
117392

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

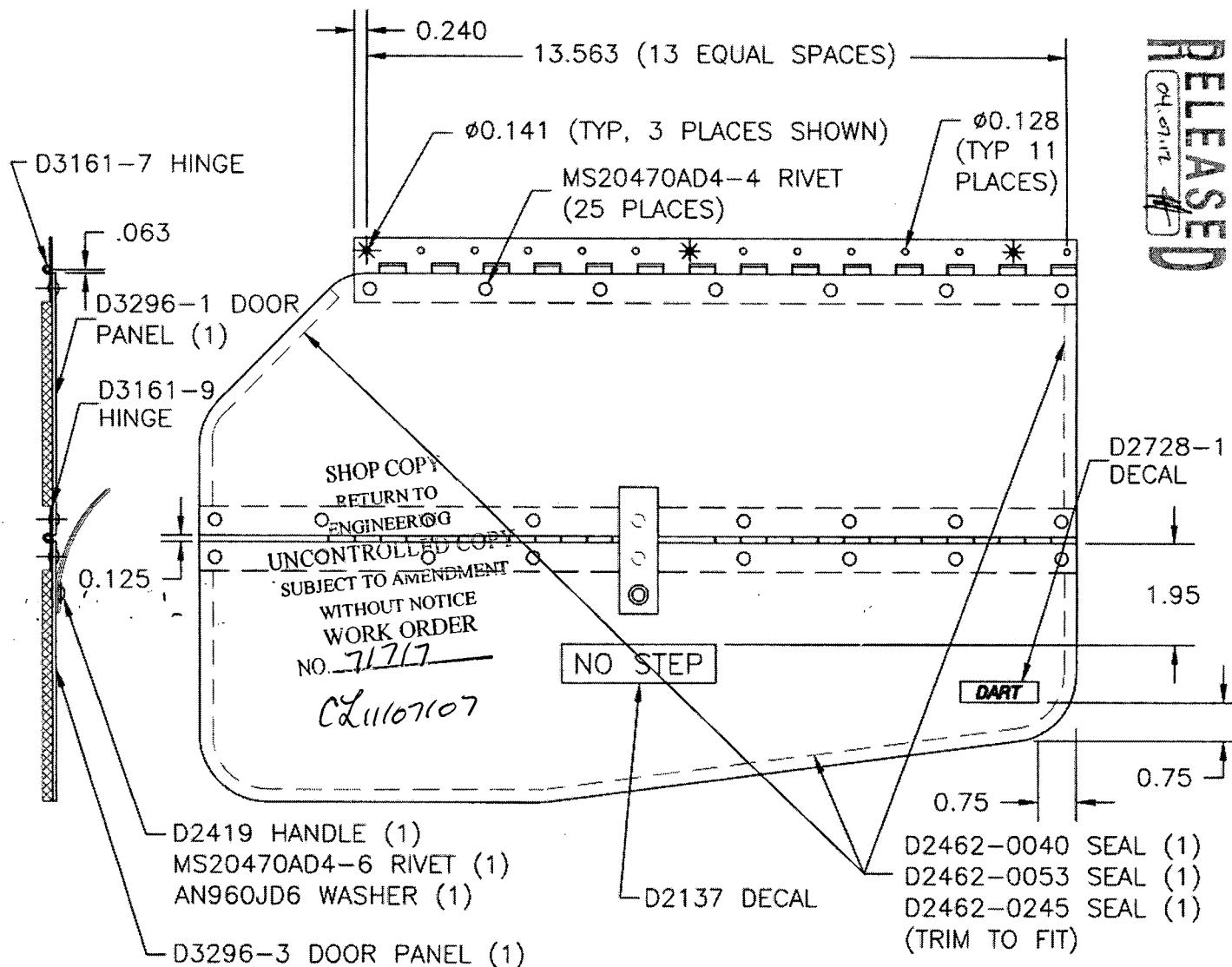
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASER  
04.07.12  
~~11~~

DESIGN			 <b>DART AEROSPACE LTD</b> <small>HAWKESBURY, ONTARIO, CANADA</small>	
CHECKED	APPROVED	DRAWN BY	REV. A	SCALE
<del>1</del>	<del>1</del>	<del>1</del>	1 OF 2	1:3
DATE	TITLE			
04.06.28	DOOR ASSEMBLY			
A	04.06.28	NEW	ISSUE	



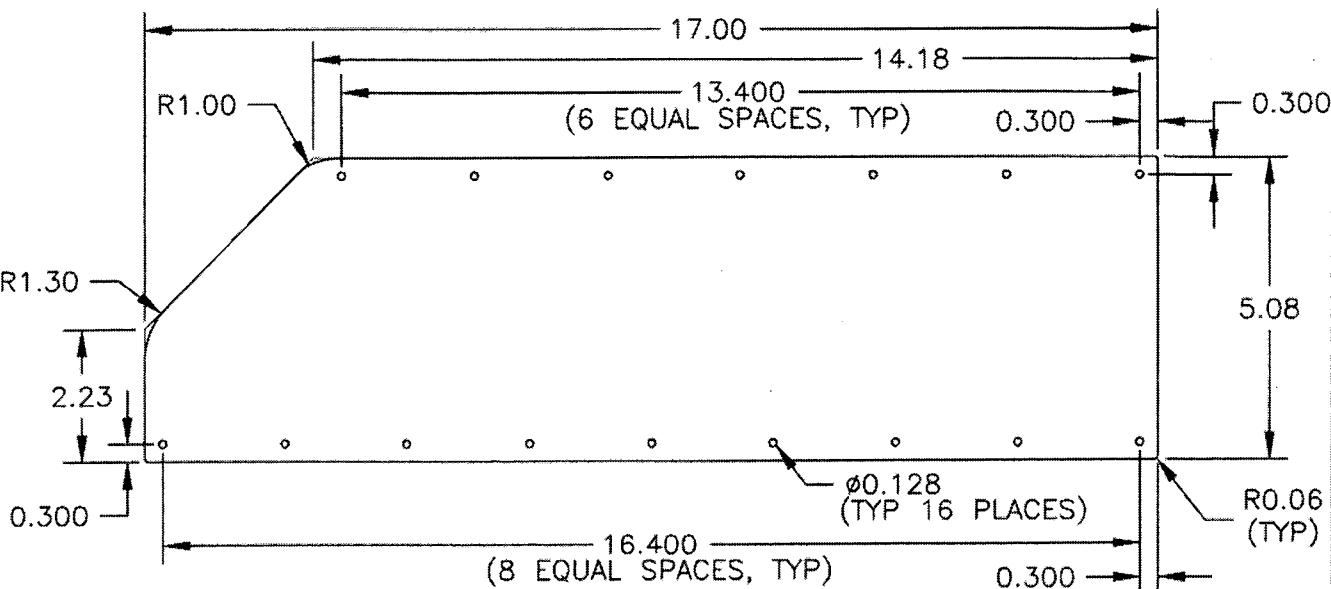
D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

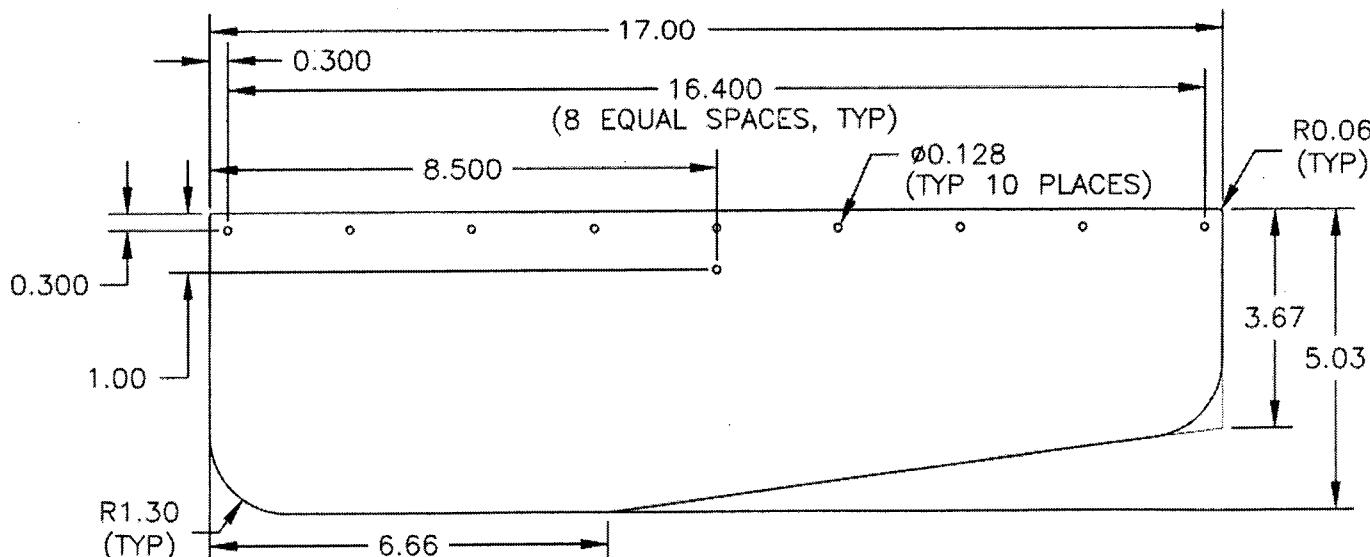


DESIGN	GP	DRAWN BY	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. A
				D3296	2 OF 2

DATE 04.06.28 TITLE DOOR ASSEMBLY SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK  
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
04.07.12

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DART AEROSPACE LTD	Work Order:	71717
Description: Door Panel	Part Number:	D3296-3
Inspection Dwg: D3296	Rev: A	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>BB</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 11-8-12	Date: 11/08/12	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	P/O D3296-041	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>